

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016966**Date Inspected:** 16-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**BAY#10**

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006675

**Ultrasonic Testing (UT)**

This QA inspector performed UT of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The member is identified as TOWER Component. The weld designation reviewed as follows:

**SOUTH TOWER LIFT-5**

SSD1 – TL5 – 1F – F – 11B; 12B; 23A; 24A; 1B

SSD1 – TL5 – 1B – F – 25A; 26A; 54; 15; 16; 18

**ORTHOTROPIC BOX GIRDER (OBG) AT BAY#10**

This QA Inspector observed the following work in progress

**Fluxcored Arc Welding (FCAW):**

Weld joint # 262 located on BP3094 – 001 Welder is identified as 057180. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T

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– 2132 – 3.

Weld joint # 36 located on Bike Path BK004A5 – 025. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 255 located on BP3094 – 001 Welder is identified as 052075. ZPMC Quality Control (QC) Inspector is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

Weld joint # 43 located on Bike Path BK004A5 – 025. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

### Heat Straightening:

Heat Straightening being performed on Bike Path identified as BK – 004 by oxy-acetylene flame method to remove the distortion that occurred after welding. ZPMC Quality Control (QC) Inspector is identified as Li Jun present at the location. This activity appeared to comply with the Heat Straightening Report # HSR1 (B) – 9343. (See attached Photo)

BAY#11

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No. 006683

### Visual Inspection Testing (VT)

This QA inspector performed VT of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as OBG Component. The identified component designations reviewed are as follows:

OBG BOTTOM PLATE

BP3091 – 001 – 013~036

### Magnetic Particle Testing (MT)

This QA inspector performed MT of the area previously tested and accepted by ZPMC Quality Control personnel.

This QA Inspector generated an MT report for this date. The member is identified as OBG Component. The weld designation reviewed as follows:

OBG BOTTOM PLATE – GREEN TAG#13706

BP3091 – 001 – 013~036

This QA Inspector observed the following work in progress

### Shielded Metal Arc Welding (SMAW):

Weld joint # 13A located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b.

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Weld joint # 9B located on Lift-5 Bracket ND1 – BRSA5 – 2. Welder is identified as 044541. ZPMC Quality Control (QC) Inspector is identified as Zhao Mao Mao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4b. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Sandeep	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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